



Dart Aerospace Ltd.
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D4435-9

Job Sheet 168850



Part No: D4435-9

Job Qty: 10 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/23/17

Job Tracking No:

Due Date: 11/29/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B SHEETS 10,11 IPP REV:A NEW ISSUE 11-12-22 JLM VERIFIED BY:EC IPP REV:B 12.01.24
PER DWG REV.A DD VERF:EC IPP REV:C 12.03.06 AS PER DWG REV.B DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/28/17	11/28/17	0.00	0.00	Start Up Waterjet		
100	Waterjet	10 pcs	11/28/17	11/28/17	0.00	0.55	Waterjet1		
120	QC	10 pcs	11/28/17	11/28/17	0.00	0.00	QC8		
130	Brake NC	10 pcs	11/28/17	11/28/17	0.03	0.29	Brake NC 2		
140	QC	10 pcs	11/28/17	11/28/17	0.00	0.00	QC5		
150	HandFinish	10 pcs	11/28/17	11/28/17	0.00	0.27	HandFinish1		
160	QC	10 pcs	11/28/17	11/28/17	0.00	0.00	QC7		
165	Powdercoat	10 pcs	11/29/17	11/29/17	0.00	0.16	Powdercoat4		
170	QC	10 pcs	11/29/17	11/29/17	0.00	0.00	QC3		
180	Packaging	10 pcs	11/29/17	11/29/17	0.00	0.00	Packaging3		
190	QC21-SA	10 Ea	11/29/17	11/29/17	0.00	0.00	QC21		

M 135418

START 11.45 OUT: 3.30

FINISH: 12.15

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.040	0	185	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	1.250Inches $\pm$ 0.030	1.280 1.220		
2	Bracket	2.800Inches $\pm$ 0.030	2.830 2.770		
3	Bracket	0.098Inches + 0.005 - 0.001	0.103 0.097	Diameter	
4	Bracket	0.130Inches $\pm$ 0.030	0.160 0.100		
5	Bracket	0.130Inches $\pm$ 0.030	0.160 0.100		
6	Bracket	0.040Inches $\pm$ 0.010	0.050 0.030		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: ☒

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval _____
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Description Work Order Deviation	Disposition
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Completed By _____ and / Supervisor _____ Approval Verification _____	
Revision: _____ Operation: _____ Change No: _____	
PART NO: _____ QA Coordinator Approval _____	

Job No: 168850
Mfg Date: 12/05/17

Start up Operation

04435 - 9

Root Cause		Pressure/Fr		Mislabeled		Finish	
Environment ☐	No Re-verification ☐	Bending ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	le Dimensions ☐	Misread ☐	Under tolerance ☐
Design ☐	Operator ☐	Centre Not ☐	Drill Holes ☐	Misaligned/off center ☐	Under tolerance ☐	Turning Sequence ☐	
Doc/Data ☐	Offset/Setup ☐	Cracks ☐			Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Crimp/Kink ☐			Under tolerance ☐		
Handling/Pre ☐	Training ☐	Cuffs ☐			Under tolerance ☐		
Material ☐	Use for Testing ☐	Crushing ☐			Under tolerance ☐		
Internal Transport ☐	Poor Information ☐	Heat Treat ☐			Under tolerance ☐		
Tribal Knowledge ☐	Rushing ☐	Wave/Twist in Tube ☐			Under tolerance ☐		
LOA ☐	Product Improvement ☐	Marks/Chatter ☐			Under tolerance ☐		
Substation ☐	Process Improvement ☐				Under tolerance ☐		
Past Expiry Date ☐	Manufacturing Process ☐				Under tolerance ☐		
Misidentified ☐	Past Due ☐	OTHER : _____			Under tolerance ☐		



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